

Work Order ID 50349



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July 13, 2009 11:23:41 AM

Item ID:	D3813-041	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Hinge Assembly, Upper Door					
Start Date:	7/15/09	Start Qty:	2.00		Cust Item ID:	
Required Date:	7/15/09	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3813	Rev A

100		0.00
	Small Fab	
Small Fab	Memo	0.00
Small Fab	1-Install helicoils as per Dwg D3813 2-Install Ball joint and nut loosely as per Dwg D3813	

EP 09/07/15 (2)

110	QC5- Inspect part completeness to step on W/O	0.00
QC	Memo	0.00
Quality Control		

=>

801/15 (2) f

120	Identify as per dwg & Stock Location	0.00
Packaging	Memo	0.00
Packaging		

135

9/7/15 (2) 81

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Item ID: D3813-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Hinge Assembly, Upper Door

Start Date: 7/15/09 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/16 *[Signature]*

MF

09-07-16

Picklist Print

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Work Order ID: 50349

Parent Item: D3813-041RevA

Parent Item Name: Hinge Assembly, Upper Door



Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3518-3RevB		Manufactured	No			100	Each	9.0000	2.0000			
										9/7/14		SP
Stainless Steel Ball Joint Rod End												

X All

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	9	
48211	9	

D3813-1RevA		Manufactured	No			100	Each	7.0000	2.0000			
										9/7/14		SP
Hinge, Upper Door												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	7	
45795	5	
46668	2	

MS124738		Purchased	No			100	Each	14.0000	2.0000			
										9/7/14		SP
Heli-Coil 3/8-24 unf												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	14	
109249	14	

(2v)

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Picklist Print

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Work Order ID: 50349

Parent Item: D3813-041RevA

Parent Item Name: Hinge Assembly, Upper Door

Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS509-6		Purchased	No			100	Each	14.0000	2.0000			



Nut

AIIX



9/7/09

SP

(2K)

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

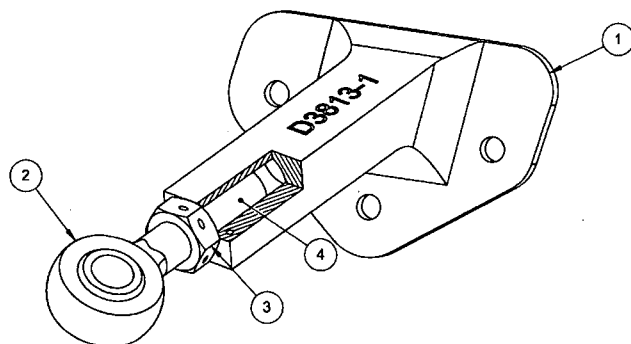
ST

14

109249

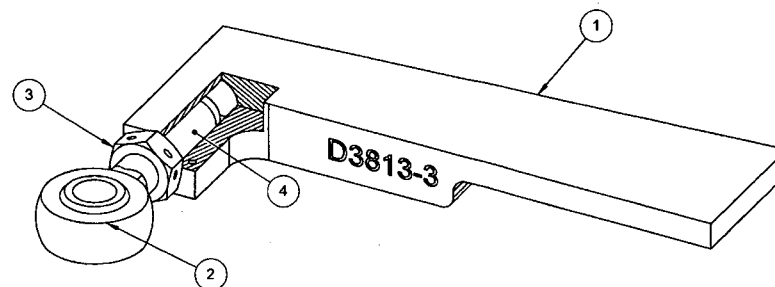
14

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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3813-1	HINGE, UPPER DOOR	1
2	D3518-3	BALL JOINT ROD END	1
3	NAS509-6	NUT	1
4	MS124738	HELI-COIL, 3/8-24 UNF	1

D3813-041 HINGE ASSY, UPPER DOOR



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -043
1	D3813-3	HINGE, LOWER DOOR	1
2	D3518-3	BALL JOINT ROD END	1
3	NAS509-6	NUT	1
4	MS124738	HELI-COIL, 3/8-24 UNF	1

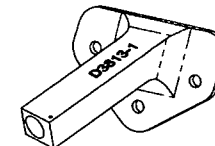
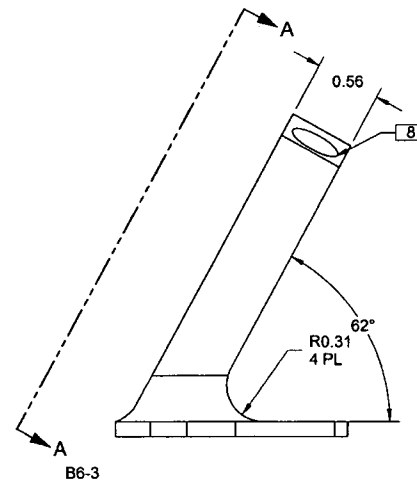
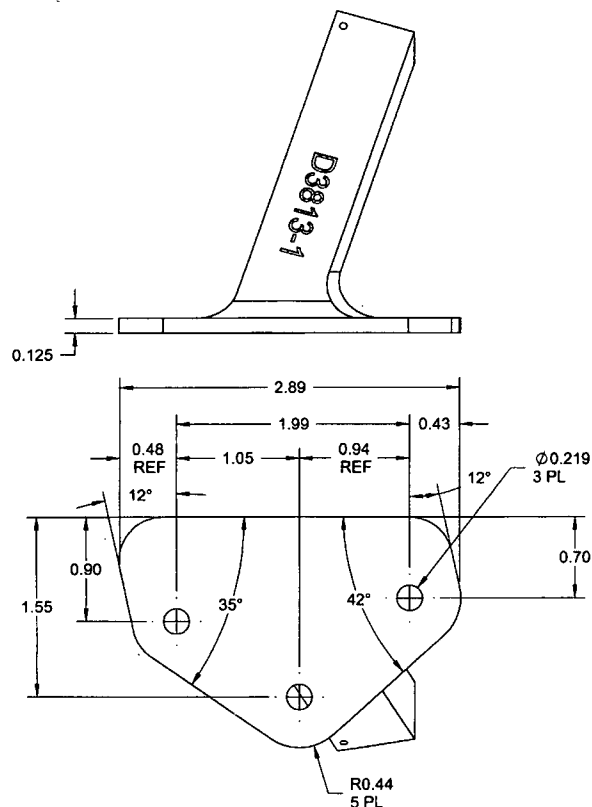
D3813-043 HINGE ASSY, LOWER DOOR

50349

RELEASED
09/01/13

A	NEW ISSUE		08.11.10
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.10		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3813	REV. A
TITLE HINGE	SHEET 1 OF 4
SCALE NTS	
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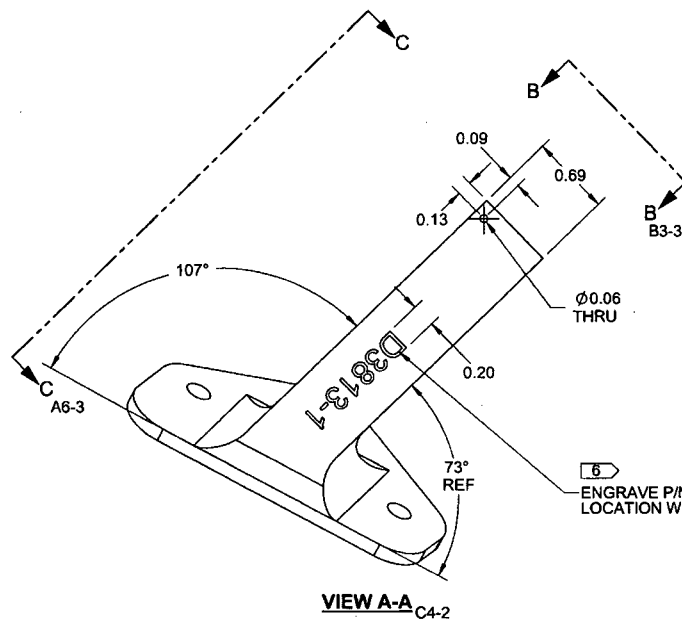
D3813-1 HINGE, UPPER DOOR

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160). (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.14 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

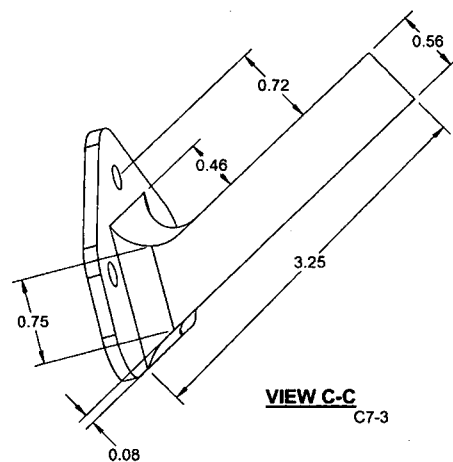
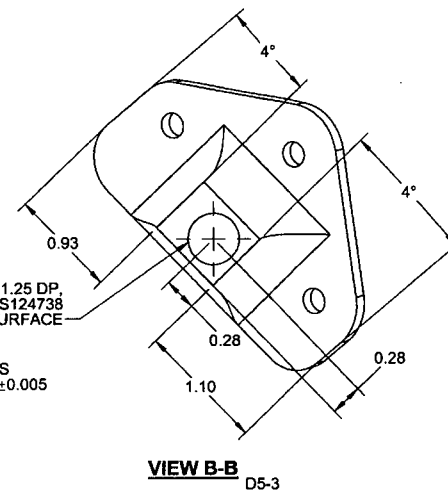
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RELEASED
09/01/10



Ø0.391 X 1.25 DP.
INSTALL HELICOIL MS124738
FLUSH WITH SURFACE

6
ENGRAVE P/N TO DEPTH OF 0.005 IN THIS
LOCATION WITH TOOL TIP RAD OF 0.015±0.005

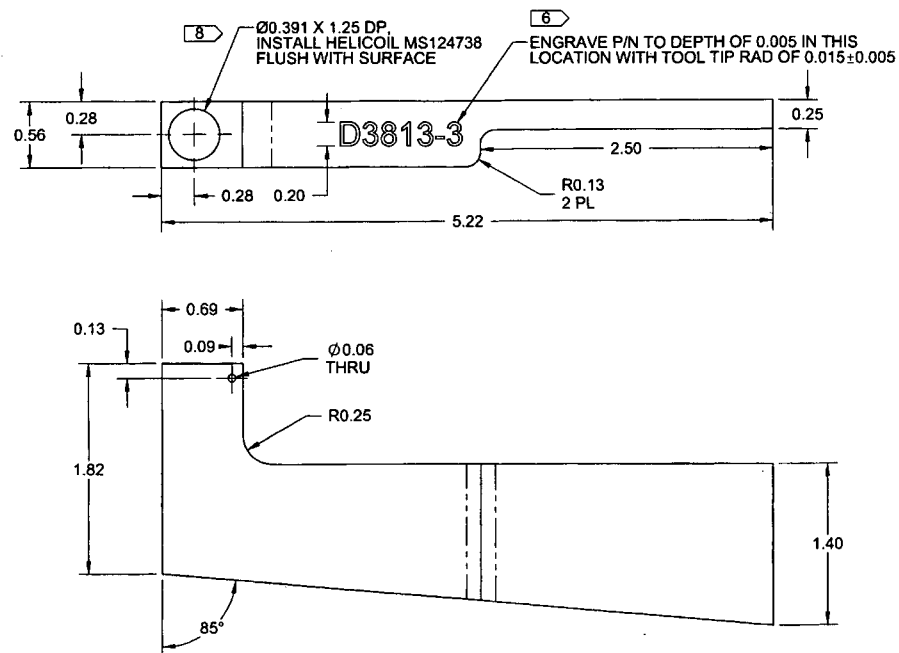


D3813-1 HINGE, UPPER DOOR

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09/01/13/10

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D3813-3 HINGE, LOWER DOOR

RELEASED
07/07/12 MJP

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.24 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

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